



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D2932-2
Job Sheet 179298

Part No: D2932-2

Job Qty: 4 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/16/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Machining-1		18/8/17
100	CNC Vertical Machining	4 pcs	6/29/18	6/29/18	0.53	4.65	HAAS1-2		
110	Mill Conv	4 pcs	6/29/18	6/29/18	0.00	0.67	Mill Conv 1		
120	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC1		
130	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs	6/29/18	6/29/18	0.00	0.22	HandFinish1		
150	Powdercoat	4 pcs	6/29/18	6/29/18	0.00	0.16	Powdercoat1		
160	QC	4 pcs	6/29/18	6/29/18	0.00	0.00	QC3		
170	Packaging	4 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1		
180	QC21-SA	4 Ea	6/29/18	6/29/18	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA014.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

Specifications could not be found.



DART Aerospace Ltd.
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Newkesbury, ON K84 1K7
CANADA
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www.dartaerospace.com

Container No: S099754



Part: D2932-2

Job No: 179298

Serial No/Batch: S099754

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/07/18

DART AEROSPACE LTD	Work Order: 179298
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	0.125	0.127	0.128		
B	0.100	0.140		0.120	0.126	0.128	0.129		
C	0.100	0.140		0.120	0.125	0.125	0.128		
D	0.210	0.230		0.227	0.227	0.226	0.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.512	0.511	0.511		
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.257	0.257	0.257	0.257		
L	0.312	0.317		0.312	0.313	0.313	0.313		
M	0.235	0.240		0.239	0.239	0.237	0.237		
N	0.100	0.140		0.120	0.120	0.120	0.120		
O	0.540	0.560		0.548	0.549	0.548	0.547		
P	0.490	0.510		0.503	0.505	0.504	0.504		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		0.260	0.266	0.266	0.263		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	VH
Date:	18/8/12

Audited by:	gumc
Date:	18/8/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____

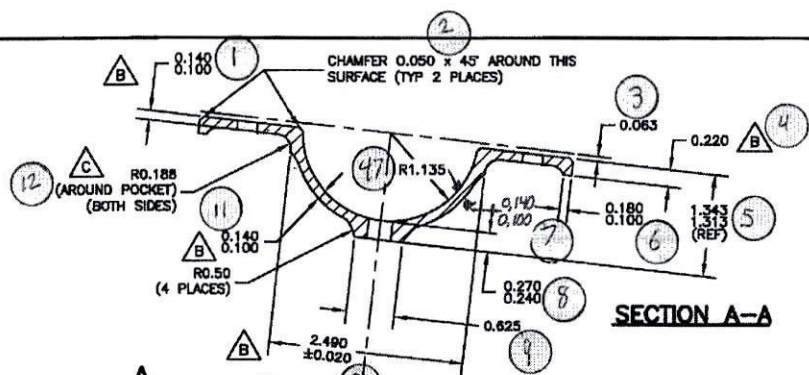


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

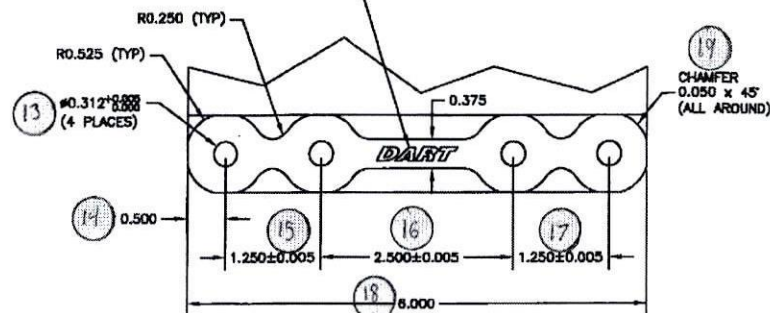
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

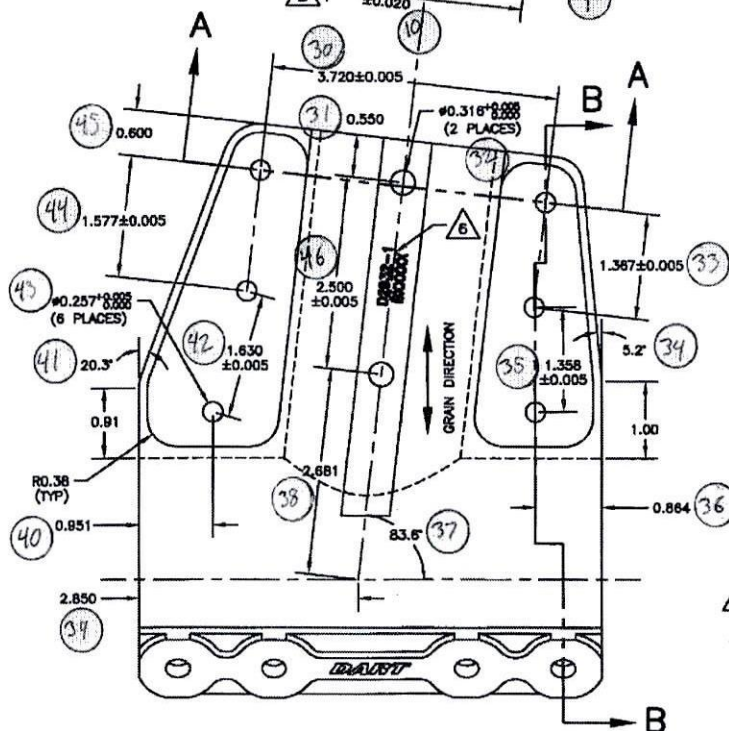


SECTION A-A

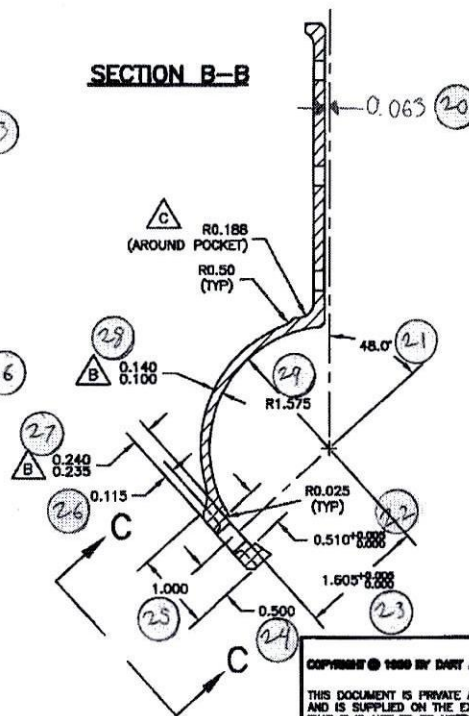
ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



VIEW C-C



SECTION B-B



D2932-1 LH SADDLE (SHOWN)

D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (Q2-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2932

REV. C

SHEET 1 OF 1

SCALE

2:3

RELEASED

07-02-12

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								